



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5550-3
Job Sheet 170806



Part No: D5550-3

Job Qty: 2 ea

Part Name: Aft Outboard Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/19/18

Job Tracking No:

Due Date: 2/26/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG D5550 REV.A SHEETS 4,5 IPP REV:A 17.09.05 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	2 Ea	2/23/18	2/23/18	0.00	0.00	Start Up Waterjet		DE 18/01/29
105	Waterjet	2 pcs	2/24/18	2/24/18	0.00	2.20	Waterjet1		DE 18/01/29
110	QC	2 pcs	2/24/18	2/24/18	0.00	0.00	QC2 Waterjet-4		DE 18/01/29
120	CNC Vertical Machining	2 pcs	2/24/18	2/24/18	0.00	6.63	HAAS1-1		
130	QC	2 pcs	2/24/18	2/24/18	0.00	0.00	QC2 Machining-4		11/18/4/12 / r.c.
140	QC	2 pcs	2/24/18	2/24/18	0.00	0.00	QC8 Machining-4		12/18-04-12
150	HandFinish	2 pcs	2/24/18	2/24/18	0.00	0.38	HandFinish1		SA 18-04-16
160	QC	2 pcs	2/24/18	2/24/18	0.00	0.00	QC7-5		BE 18-4-17
170	Powdercoat	2 pcs	2/26/18	2/26/18	0.00	0.18	Powdercoat1		BE 18-4-17
180	QC	2 pcs	2/26/18	2/26/18	0.00	0.00	QC3		11 APR 23 2018
190	Packaging	2 pcs	2/26/18	2/26/18	0.00	0.00	Packaging3-2	504/11	21 9-89
200	QC21-SA	2 Ea	2/26/18	2/26/18	0.00	0.00	QC21		0-80 APR 23 2018

Part Op 105 - ***GRAIN DIRECTION*** 1-Cut contour and pocket as per Dwg Dwg Rev: A Prog Rev: A 2-Debuff if
Descriptions: necessary

120 - Face and Drills holes as per dwg Dwg Rev: _____

170. ***Mask holes or blow out access powdercoat in holes*** START TIME: 1:15 OVEN TEMPERATURE:

320° FINISH TIME: 1:45 M B 8760

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X12.000	6061-T6 Bar 1.00 X 12.00	4.8000 ft (2.4 ea)	90-Start up Operation	

X1 6061T6B1.000 X 12.000 50109251 505157

Part Specifications

Specifications could not be found.

Plex 1/19/18 1:14 PM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____	Part NO: D5550-3 Original Serial #: S041819 Revision: Operation: Change No:	Aft Outboard Beam S041819 DART AEROSPACE	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th colspan="4" style="text-align: left;">AGAINST DEPARTMENT/PROCESS</th> </tr> <tr> <td style="width: 25%;">Mid-tube ☐</td> <td style="width: 25%;">Cross tube ☐</td> <td style="width: 25%;">Water Jet ☐</td> <td style="width: 25%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Forming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> <tr> <td colspan="3">EFFECTIVE : _____</td> <td>MRB (QSI042) Approval</td> </tr> <tr> <td colspan="3" style="text-align: center;">Disposition</td> <td>Completed By</td> </tr> <tr> <td colspan="3" rowspan="2"></td> <td>Lead hand / Supervisor Approval Verification</td> </tr> <tr> <td>QC / QA Coordinator Approval</td> </tr> </table>	AGAINST DEPARTMENT/PROCESS				Mid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Forming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐		EFFECTIVE : _____			MRB (QSI042) Approval	Disposition			Completed By				Lead hand / Supervisor Approval Verification	QC / QA Coordinator Approval																																																			
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Job No: 170806
Start up Operation 02/13/18

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 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL.: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

DART AEROSPACE LTD		Work Order:	170806
Description: AIT Outboard Beam		Part Number:	D5550.3
Inspection Dwg: 5550 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø1.25	-0.001 +0.042	Ø1.249	1			
2.00	+/- .030	1.996	1			
3.50	+/- .030	3.510	1			
6.34	+/- .030	6.329	1			
13.00	+/- .030	13.00	1			
21.00	+/- .030	21.00	1			
17.39	+/- .030	17.39	1			
Ø0.377"	± 0.006 / -0.001	Ø0.378"	✓		Verifier	CNC-19
Ø0.191"	+0.005 / -0.001	Ø0.192"	✓		"	" "
0.60"	± 0.030"	0.595/0.598"	✓		"	" "
0.63"	"	0.625"	✓		"	" "
1.800"	± 0.010"	1.798"	✓		"	" "
3.600	"	3.598"	✓		"	" "
2.300"	"	2.302/2.301"	✓		"	" "
0.375"	± 0.010"	0.378"	✓		"	" "
0.75"	± 0.030"	0.750"	✓		"	" "
1.500"	± 0.010	1.501"	✓		"	" "
3.000"	"	3.001"	✓		"	" "
3.750"	"	3.750"	✓		"	" "
1.150"	"	1.148"	✓		"	" "

Measured by: J.C.L. / 18/4/12	Audited by: DAS 20 9.86	Preliminary Approval:
Date: 18/04/12	Date: 18-04-12	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	